

Work Order ID 75151

75151

Page 1

October-18-11 2:44:12 PM

Item ID: D3065-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 18/10/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3065	Rev B

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3065 Dwg Rev: B Prog Rev: B 2-
 2024 . 040 Debur as required

B11-11-2

(52)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B11-11-2

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

11-11-03

(52)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75151

October-18-11 2:44:12 PM

N900040100

Setup Start *NS1*

Stop *NS2*

40

40

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

130

Small Fab

Memo

Deburr if necessary.

N/A

0.00

0.00

0.00

140

NC BRAKE

Memo

Bend as per Dwg D3065

0.00

20/11/14



0.00

150

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Solving

count
52

W/O:		WORK ORDER CHANGES					
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October-18-11 2:44:12 PM

N900040100

Setup Start *NS1*

Stop. *NS2*

40

40

Customer:

Run Start *NR1*

Stop ***NID2***

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

160 Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170 QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

180 Identify as per dwg & Stock Location:

0.00

180

Packaging

Memo

0.00

Packaging

52xx m. / 11/11/15

52x d M u(u)15

முதுகு

EB 11/11/18 (52)

W/O:		WORK ORDER CHANGES					
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Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

11/11/21 *[Signature]*
 11/11/18
 (S2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

October-18-11 2:44:17 PM

Page 1

Work Order ID: 75151

75151

Parent Item: D3065-1

D3065-1

Parent Item Name: Step Spacer

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: C02.11.01 Incorporated D3066-1 IPPKJ/RF
IPP: D06.04.25 Water jet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040 Purchased No

100 sf

112.5184

0.1238

5.212632

6.5

M2024T3S 040

**

B11-11-2

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

112.518421

113162

1.1

117684

111.418421

117684

S2

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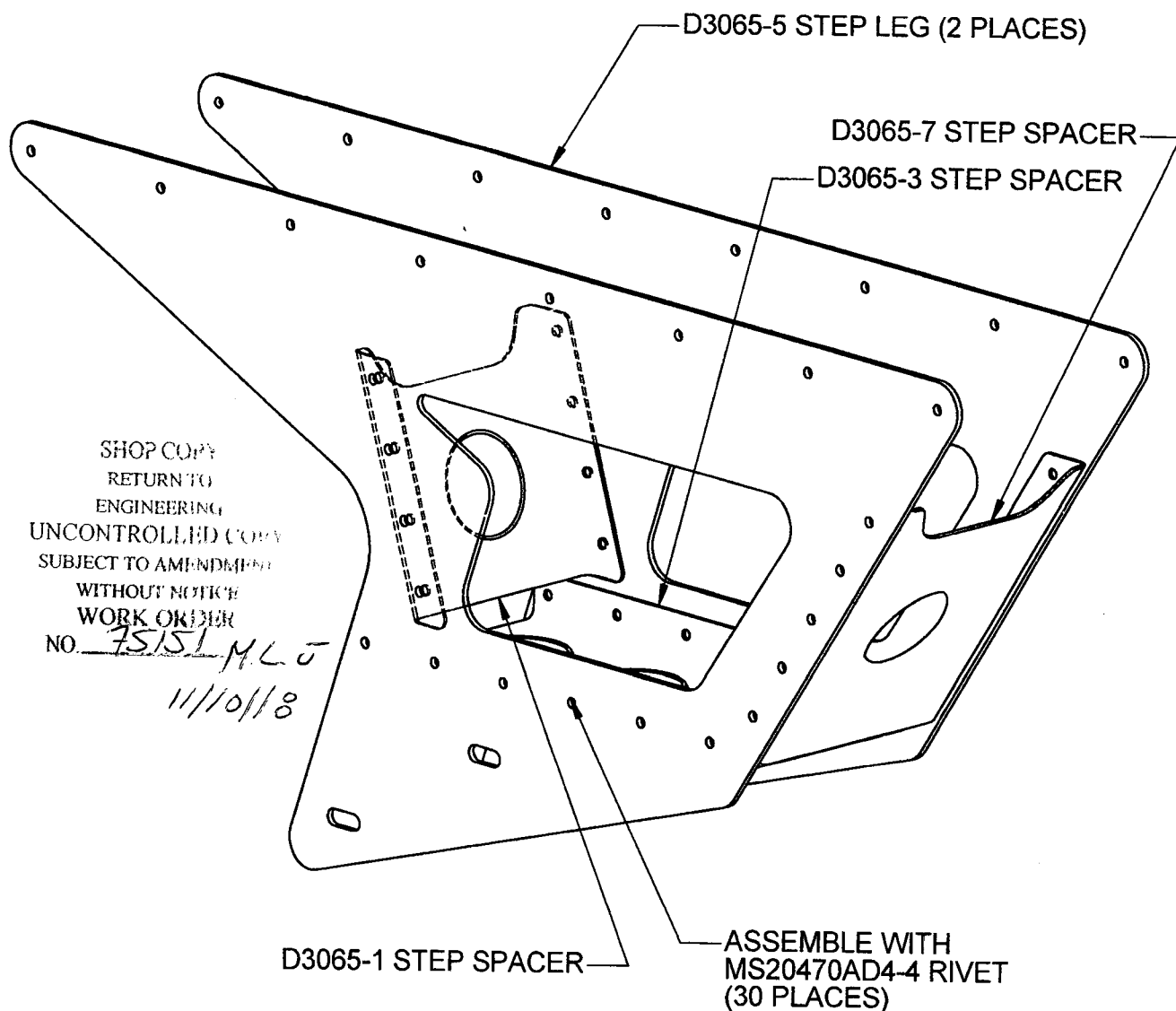
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06.06.20* *[Signature]***D3065-041 STEP LEG ASSEMBLY****COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

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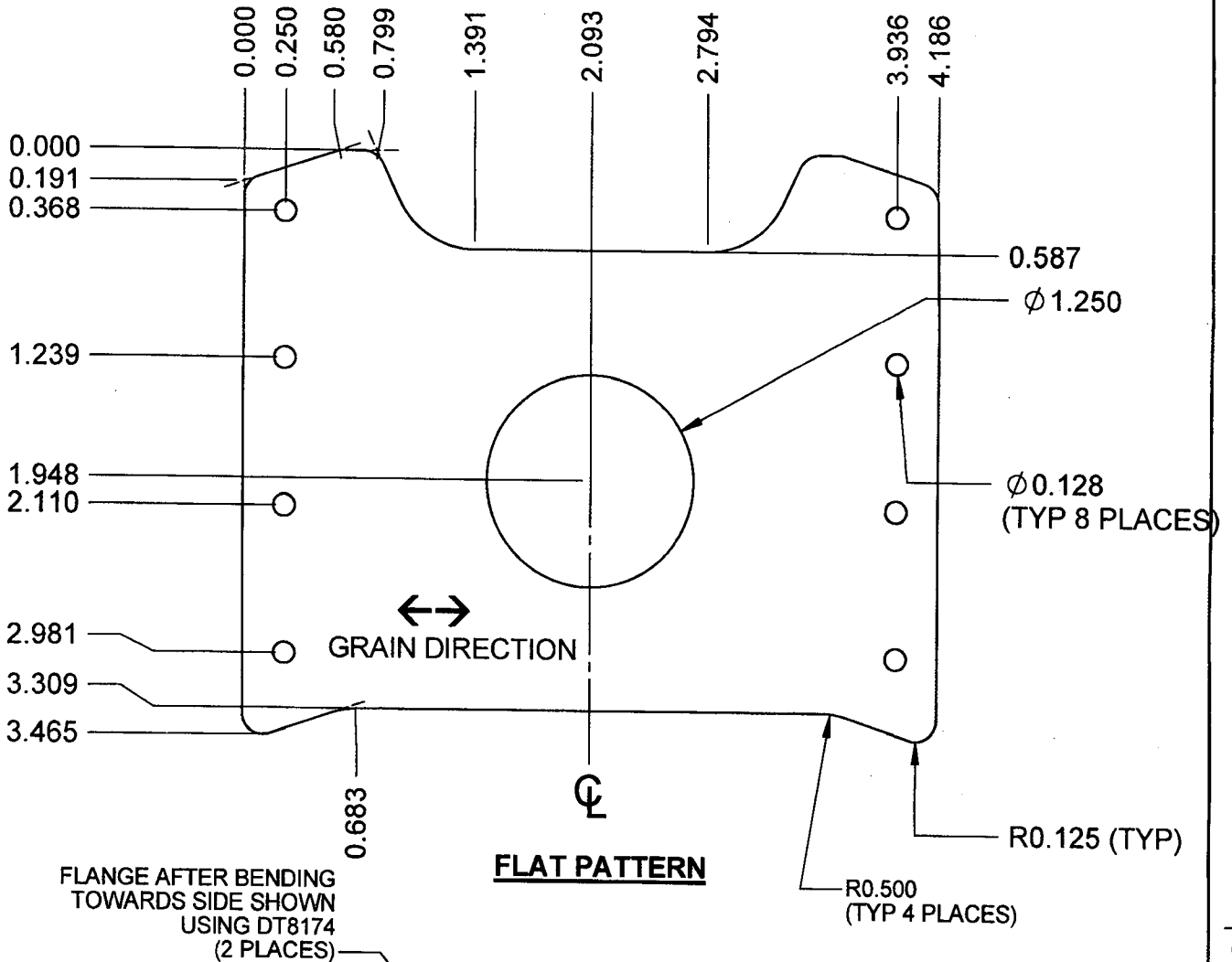
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**RELEASED***CP CB PH***D3065-1 STEP SPACER****BEND DETAIL**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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